

Date: Friday, 5/25/2007 8:15:51 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: ANGLE
Job Number	: 32570		
Estimate Number	: 10196		
P.O. Number	: <i>N/A</i>	Part Number	: D21751
This Issue	: 5/25/2007	S.O. No.	: <i>N/A</i>
Prsht Rev.	: NC	Drawing Number	: D2175 REV E
First Issue	: <i>N/A</i>	Project Number	: N/A
Previous Run	: 31690	Drawing Revision	: E
		Material	: <i>N/A</i>
Written By	:	Due Date	: 6/20/2007
Checked & Approved By	:	Qty:	20 Um: Each
Comment	: Est E 04-06-09 Reformat KJ/RF		
	: Est Rev:F 06-04-28 Manufactured on Water Jet JLM		
	: Est Rev:G As per Rev E 06-11-22 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M2024T3S063	2024-T3 .063 sheet
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Comment: Qty.: 0.4958 sf(s)/Unit Total : 9.9162 sf(s)
 Material: 2024-T3 (QQ-A-250/4) 0.063" thick
 (M2024T3S.063) Batch: *ml 070612*

(20)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2175
 Dwg Rev: *E*
 Prog Rev: *E*

ml 070612

(20)

2-Deburr if necessary

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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*ml 070612*

(20)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

En 07/06/12

(20)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr Stack

ml 07/06/12 21 20

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: D Date: 01/09/25
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 5/25/2007 8:15:51 AM
User: Kim Johnston

Process Sheet

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Part Number: D21751

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form as per Dwg D2175

SB 07/09/24

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SA 07/08/24 (20)

8.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

BL 07-09-24 (20)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT CHEMICAL CONVERSION COAT

CP 07/09/25 (20)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 5177

CP 07/09/25 (20)

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

CP 07/09/25 (20)

Job Completion



U 07-09-25

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	32510
Description: Angle		Part Number:	D2175-1/-2
Inspection Dwg: D2175 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
12.650	+/-0.010	12.650	✓		M-T	
R0.35	+/-0.030	R0.35	✓		R-G	
2.915	+/-0.010	2.919	✓		VENN	
50°	+/-0.5°	50°	✓		A-M	
0.300	+/-0.010	0.305	✓		VENN	
1.050 Pitch	+/-0.010	1.053	✓		VENN	
10.500	+/-0.010	10.500	✓		M-T	
11.550	+/-0.010	11.550	✓		M-T	
0.550	+/-0.010	0.548	✓		VENN	
0.900	+/-0.010	0.903	✓		VENN	
0.063 thick	+/-0.010	0.063	✓		VENN	
Grain Direction	N/A					
Ø0.128	+0.005/-0.001	0.130	✓		VENN	
Ø0.172	+0.005/-0.001	0.173	✓		VENN	

Measured by:	ML ML	Audited by:	En	Prototype Approval:	N/A
Date:	07 06 12	Date:	07/06/12	Date:	N/A

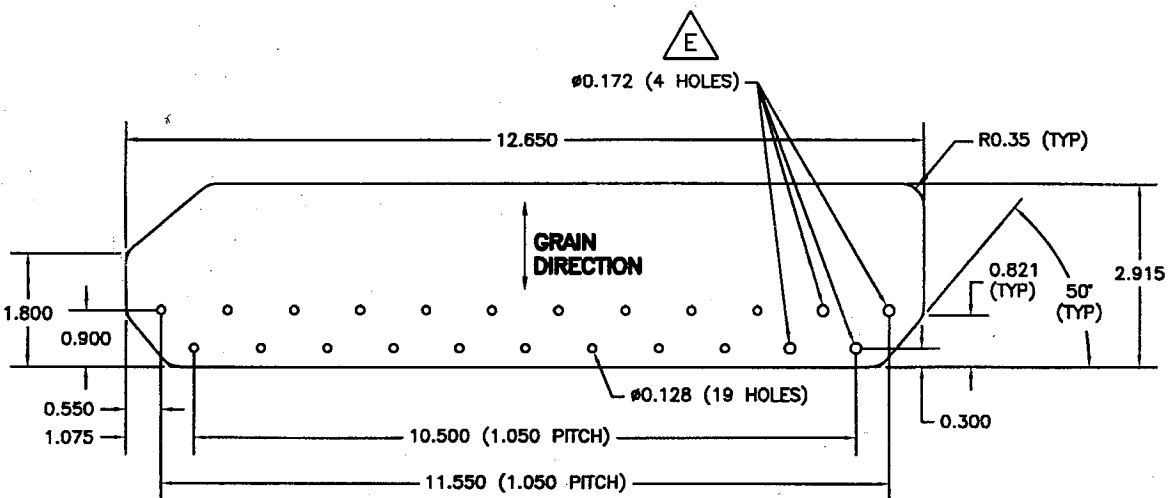
Rev	Date	Change	Revised by	Approved
A	04.08.12	New Issue	KJ/JLM	
B	07.03.23	Dimensions revised per Dwg rev. E	KJ/JLM	

086

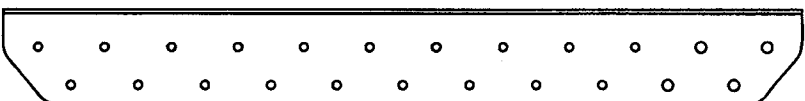


RELEASED
06.10.13

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
RF	CE	DRAWING NO.	REV. E	
CHECKED PH	APPROVED [Signature]	D2175	SHEET 1 OF 1	
DATE 06.09.25	TITLE ANGLE	SCALE 1:3		
A	95.10.25	NEW ISSUE		
B	96.01.18	CHANGED DIMENSION		
C	00.09.11	UPDATE FINISH SPEC		
D	04.06.03	RE-DESIGN		
E	06.09.25	INC HOLE DIA TO Ø0.172, 4 HOLES		



D2175-1F. FLAT PATTERN



**D2175-1 BEND DETAIL SHOWN
(D2175-2 BENT OPPOSITE)**

- NOTES:**
- 1) MATERIAL: 2024-T3 (QQ-A-250/4) SHEET 0.063 THICK (REF. DART SPEC. M2024T3S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010
 - 5) ALL DIMENSIONS ARE IN INCHES

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROL
SUBJECT TO AME
WITHOUT NOTICE

WORK ORDER
NO. 22570